

Work Order ID 82872

April-10-12 2:34:38 PM

82872

Page 1

Item ID: D205-778-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Comfort Seat, LH/RH

Stop *NS2*

Start Date: 10/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/04/10

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3800	B
-------	---

DSI 9508	A
----------	---

IIN D205-778	Rev B
--------------	-------

100

DOCUMENT CONTROL

0.00

100

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D205-778-011 CHG 003

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

for M.L.J 12-4-17

12/4/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82872

82872

Page 2

April-10-12 2:34:38 PM

Item ID: D205-778-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Comfort Seat, LH/RH

Start Date: 10/04/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00		5/26/18		(H)			
130 *130* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D205-778-101 Location: 49 Orange Place PPP Rev: 6	0.00 0.00				(X)		12/4/18	
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						12/4/19	

MF
12-04-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-10-12 2:34:41 PM

Page 1

Work Order ID: 82872

82872

Parent Item: D205-778-011

D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-10-20 New Issue DD verified by:EC
per DSI 9508 DD 10.03-24 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960JD6L

Purchased

No

110

Each

624.0000

16

16

**

*AN960.ID6I *

Washer

Location

Loc Qty

Loc Code

ST337A

624

5519

624

16

BSP-42

Purchased

No

110

Each

258.0000

8

8

**

BSP-42

Rivet

Location

Loc Qty

Loc Code

ST281

200

121163

200

ST284

58

114598

8

120930

50

8

D3752-1

Manufactured

No

110

Each

2.0000

1

1

**

D3752-1

Seat Frame

Location

Loc Qty

Loc Code

ST252A

2

80365

2

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-10-12 2:34:41 PM

Page 2

Work Order ID: 82872

82872

Parent Item: D205-778-011

D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3755-041

Manufactured No

110

Each

5.0000

1 1

**

D3755-041

Seat Cushion

Location

Loc Qty

Loc Code

ST252A

1

80372

1

ST258A

4

81290

4

D3756-041

Manufactured No

110

Each

5.0000

1 1

**

D3756-041

Cushion

Location

Loc Qty

Loc Code

ST252A

1

80373

1

ST258A

4

81291

4

D3758-041

Manufactured No

110

Each

1.0000

2 2

**

D3758-041

Clamp

Location

Loc Qty

Loc Code

ST458

1

73159

1

D3777-041

Manufactured No

110

Each

22.0000

2 2

**

D3777-041

Clamp

Location

Loc Qty

Loc Code

ST458

22

73975

22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-10-12 2:34:41 PM

Page 3

Work Order ID: 82872

82872

Parent Item: D205-778-011

D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3800-3-200

Manufactured No

110 f

100.2800

2

2.105263

D3800-3-200

Hook and Loop Strip (2" Hard)

**

Location

Loc Qty

Loc Code

ST064

100.28

56393

40.28

60044

60

1- Cut to length as per dwg (4x 6.00")

AN525-10R8

Purchased No

110 Each

279.0000

8

8

AN525-10R8

Screw

**

Location

Loc Qty

Loc Code

ST345

279

119307

3

120986

76

121165

200

AN970-3

Purchased No

110 Each

233.0000

8

8

AN970-3

Washers

**

Location

Loc Qty

Loc Code

ST344

233

117395

3

120308

6

120644

24

121163

200

AN960JD10

NAS1149D0363J

Purchased No

110 Each

0.0000

8

8

AN960JD10

Washer

**

m120644 12/14/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-10-12 2:34:41 PM

Page 4

Work Order ID: 82872

82872

Parent Item: D205-778-011

D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

100

Each

2,198.000

8

8

MS21042L3

Nut

**

calderon

Location

Loc Qty

Loc Code

ST300

2198

117441

16

117885

32

118451

5

118927

3

119017

1976

119075

166

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-778 REV. B
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-778 REV. 1

REF TCCA STC: SH08-37

REF FAA STC: SR02704NY

REF EASA STC: EASA.IM.R.S.01518

PURPOSE:

To provide instructions to allow the hook strip (ie. velcro) on the D3752-1 Seat Frame to be fastened with rivets.

CHANGE:

D205-778-011 Comfort Seat Kits at CHG 002 have rivets and washers that may be installed to fully secure the D3800-3-200-060 Hook Strip to the D3752-1 Seat Frame. The parts list of Installation Instructions IIN-D205-778 and Instructions for Continued Airworthiness ICA-D205-778 is amended as shown below. Installation of the rivets is optional.

PARTS LIST

QTY -011	Part Number	Description
X	D205-778-011	Comfort Seat Kit
8	BSP-42	Rivet (Add)
16	NAS1149DN616J	Washer (or AN960JD6L) (Add)

INSTALLATION INSTRUCTIONS

Install the BSP-42 rivets as detailed below, see Figure 1 of this service instruction as reference:

- 1) Ensure location of D3800-3-200-060 Hook Strip lines up with loop strip on seat cushions.
- 2) Drill D3752-1 Seat Frame using 9/64" (Ø0.141) drill in appropriate locations: ensure rivet location will not interfere (contact) with the OEM metal seat frame. Deburr hole.
- 3) Install each BSP-42 rivet with qty(2) NAS1149DN616J washers (one on either side of the plastic seat frame). It is acceptable to substitute longer/shorter BSP rivets or thicker NAS1149DN632J washers to ensure proper fit.

UPGRADE KIT

For D205-778-011 Comfort Seat Kits at CHG 001, the DSI-9508-011 Rivet Kit is available from Dart:

QTY -011	Part Number	Description
X	DSI-9508-011	Rivet Kit
8	BSP-42	Rivet
16	NAS1149DN616J	Washer (or AN960JD6L)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 82872
12/04/10

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.03.02
CERT. NO.: SH08-37
ISSUE NO.: 1

A	NEW ISSUE	CP	10.03.02
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>qp</i>		
CHECKED	<i>13</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>N/A</i>	DSI 9508	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIVET KIT	NTS
DATE	10.03.02	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

BSP-42 RIVET, 1x
 NAS1149DN616J RIVET, 2x
 2 PL PER HOOK STRIP

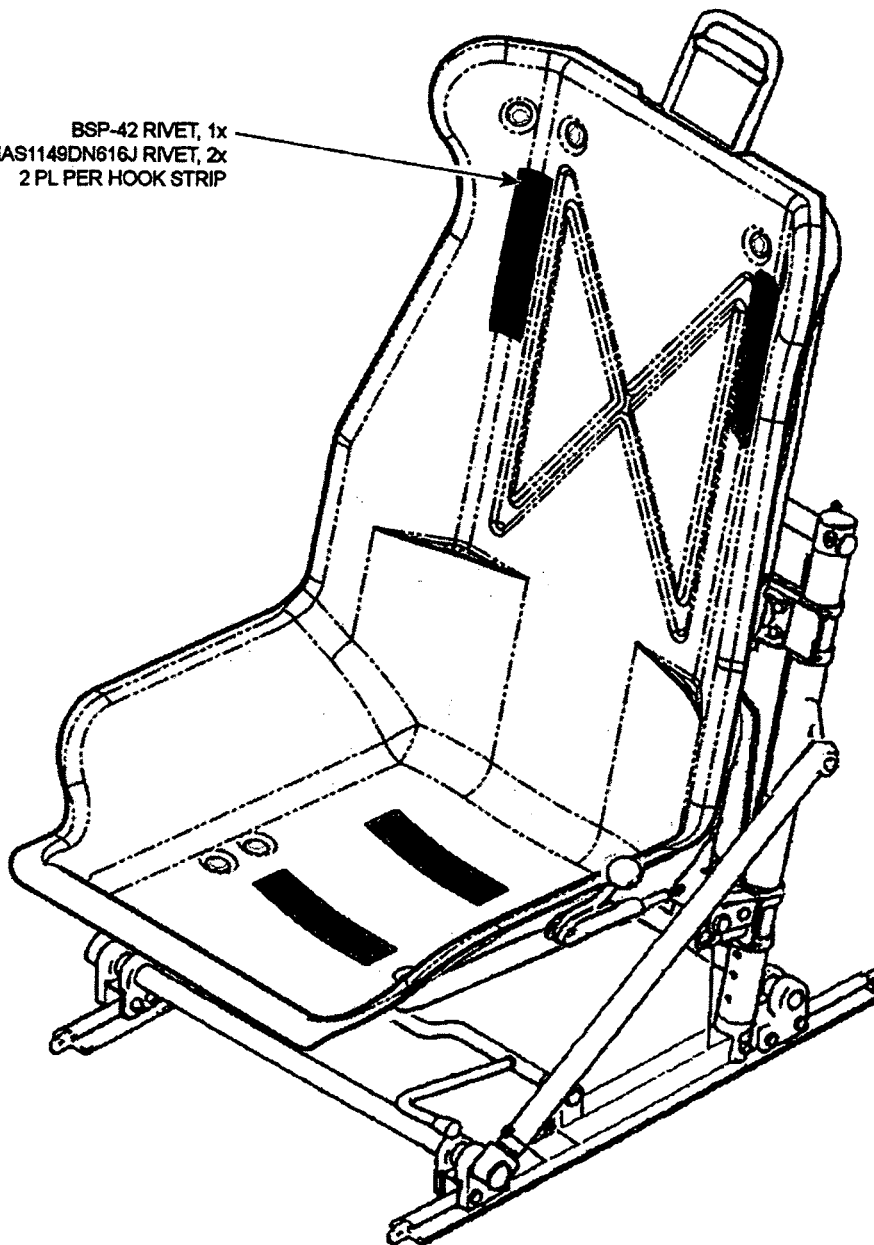


FIGURE 1: RIVET INSTALLATION
 (CUSHIONS NOT SHOWN)





82842

CANADA
 DEPARTMENT OF TRANSPORT
 AIRCRAFT CERTIFICATION
 BRANCH
 DAO # 01-O-01

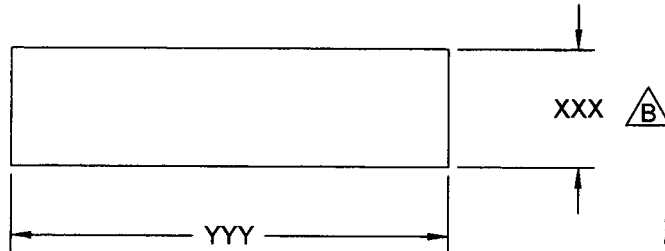
APPROVED

BY: *[Signature]*
 D. SHEPHERD (DE # 02)

DATE: 10.03.02
 CERT. NO.: SH08-37
 ISSUE NO.: 1

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9508	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		RIVET KIT	NTS
DATE	10.03.02	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

SPECIFICATION CONTROL DRAWING



DESCRIPTION: HOOK AND LOOP STRIP WITH ADHESIVE BACK

SPECIFICATION: D3800-1-XXX-YYY LOOP STRIP (ie. SOFT VELCRO STRIP) B
 D3800-3-XXX-YYY HOOK STRIP (ie. HARD VELCRO STRIP) B

WHERE 'XXX' IS WIDTH IN HUNDREDTHS OF AN INCH
 AND 'YYY' IS LENGTH IN TENTHS OF AN INCH

EG. 1" WIDE BY 2.5" LONG LOOP STRIP = D3800-1-100-025
 2" WIDE BY 10.0" LONG HOOK STRIP = D3800-3-200-100

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 82872 MJS
 12/04/10

PART NUMBER	WIDTH	PURCHASE	B
D3800-1-100-YYY LOOP STRIP	1.0	McMASTER CARR P/N: 9776K122, 9776K126, 9776K18, 9776K28, 9776K131, 9776K38	B
D3800-3-100-YYY HOOK STRIP	1.0	McMASTER CARR P/N: 9776K97, 9776K113, 9776K13, 9776K23, 9776K117, 9776K33	B
D3800-1-100-YYY & D3800-3-100-YYY (PURCHASED AS COMBINATION PACK)	1.0	McMASTER CARR P/N: 9776K72, 9776K76, 9776K79, 9776K84, 9776K88, 9776K93	B
D3800-1-200-YYY LOOP STRIP	2.0	McMASTER CARR P/N: 9776K123, 9776K127, 9776K19, 9776K29, 9776K132, 9776K39	
D3800-3-200-YYY HOOK STRIP	2.0	McMASTER CARR P/N: 9776K98, 9776K114, 9776K14, 9776K24, 9776K118, 9776K34	
D3800-1-200-YYY & D3800-3-200-YYY (PURCHASED AS COMBINATION PACK)	2.0	McMASTER CARR P/N: 9776K73, 9776K77, 9776K81, 9776K85, 9776K89, 9776K94	

NOTES:

- 1) MATERIAL: WOVEN NYLON HOOK AND LOOP WITH ADHESIVE BACK
 BEIGE COLOR
 ACCEPTABLE SUPPLIERS PER ABOVE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

RELEASED

B	ADD 1" WIDTH OPTION, "XXX-YYY" WAS "XXX", ADD ADDITIONAL McMASTER PART NUMBERS	CP	08.09.09
A	NEW ISSUE	CP	08.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>GP</i>		
CHECKED	<i>PH</i>	DRAWING NO. D3800	REV. B
MFG. APPR.	<i>BE</i>	SHEET 1 OF 1	
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>MD</i>	HOOK AND LOOP STRIP	NTS
DATE	08.09.09	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-778-011	13.0 lb	±22.0 in	±286 in-lb	47.0 in	611 in-lb
Comfort Seat Kit, LH / RH	5.9 kg	±0.56 m	±3.3 m-kg	1.19 m	7.0 m-kg

5.0 PARTS LIST

Qty -011	Part Number	Description
X	D205-778-011	COMFORT SEAT KIT (FITS LH & RH)
1	D3752-1	SEAT FRAME
1	D3755-041	CUSHION
1	D3756-041	CUSHION
2	D3758-041	CLAMP ASSEMBLY
*2	D3758-1	CLAMP
*2	D2182B028	RUBBER CUSHION
2	D3777-041	CLAMP ASSEMBLY
*2	D3777-1	CLAMP
*2	D2182B013	RUBBER CUSHION
4	D3800-3-200-060	HOOK STRIP
8	AN525-10R8	SCREW
8	AN970-3	WASHER
8	AN960JD10	WASHER
8	MS21042L3	NUT (OR MS21042-3)

* REFERENCE ONLY. PARTS ARE INCLUDED IN ASSEMBLY ABOVE.

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-778 REV. B
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-778 REV. 1

REF TCCA STC: SH08-37

REF FAA STC: SR02704NY

REF EASA STC: EASA.IM.R.S.01518

REFERENCE

PURPOSE:

To provide instructions to allow the hook strip (ie. velcro) on the D3752-1 Seat Frame to be fastened with rivets.

CHANGE:

D205-778-011 Comfort Seat Kits at CHG 002 have rivets and washers that may be installed to fully secure the D3800-3-200-060 Hook Strip to the D3752-1 Seat Frame. The parts list of Installation Instructions IIN-D205-778 and Instructions for Continued Airworthiness ICA-D205-778 is amended as shown below. Installation of the rivets is optional.

PARTS LIST

QTY -011	Part Number	Description
X	D205-778-011	Comfort Seat Kit
8	BSP-42	Rivet (Add)
16	NAS1149DN616J	Washer (or AN960JD6L) (Add)

INSTALLATION INSTRUCTIONS

Install the BSP-42 rivets as detailed below, see Figure 1 of this service instruction as reference:

- 1) Ensure location of D3800-3-200-060 Hook Strip lines up with loop strip on seat cushions.
- 2) Drill D3752-1 Seat Frame using 9/64" (Ø0.141) drill in appropriate locations: ensure rivet location will not interfere (contact) with the OEM metal seat frame. Deburr hole.
- 3) Install each BSP-42 rivet with qty(2) NAS1149DN616J washers (one on either side of the plastic seat frame). It is acceptable to substitute longer/shorter BSP rivets or thicker NAS1149DN632J washers to ensure proper fit.

UPGRADE KIT

For D205-778-011 Comfort Seat Kits at CHG 001, the DSI-9508-011 Rivet Kit is available from Dart:

QTY -011	Part Number	Description
X	DSI-9508-011	Rivet Kit
8	BSP-42	Rivet
16	NAS1149DN616J	Washer (or AN960JD6L)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.03.02
CERT. NO.: SH08-37
ISSUE NO.: 1

A	NEW ISSUE	CP	10.03.02
REV.	DESCRIPTION	BY	DATE
DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9508	SHEET 1 OF 2
APPROVED	92	TITLE	SCALE
DE APPR.	92	RIVET KIT	NTS
DATE	10.03.02	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	